

Work Order ID 67520

Monday, March 28, 2011 7:24:58 AM



Page 1

Item ID: D3183-045

Revision ID:

Item Name: Bearing Assembly

Start Date: 3/28/2011

Start Qty: 50.00
3048

Required Date: 3/30/2011

Req'd Qty: 50.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
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Draw Nbr	Revision Nbr
D3183	Rev C1

100



Hardinge

Hardinge CNC LATHE SMALL

0.00

ad 11.3.28

50

Hardinge CNC Lathe Small

Memo

0.00

Turn D3183-9 Cap as per Folio FA388 | Deburr

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

ad 11.3.28

50

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

ad 11.3.28

50

Memo

0.00

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 67520

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Item ID: D3183-045

Accept



Setup

Start



Revision ID:

Item Name: Bearing Assembly

Stop



Start Date: 3/28/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID
130



Small Fab

Small Fab

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

0.00

Memo

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sub 31

cont'd

38

150



Packaging

Packaging

Identify as per dwg & Stock Location: 230

0.00

Memo

0.00

11/4/11 380

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 67520

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Item ID: D3183-045

Accept



Setup Start



Revision ID:

Item Name: Bearing Assembly

Stop



Start Date: 3/28/2011 Start Qty: 50.00



Cust Item ID:

Required Date: 3/30/2011 Req'd Qty: 50.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

Tool ID

Tool #

Plan

Accept

Reject

Reject

Number

Insp.
Stamp

0.00

0.00

11/04/04 JJ

QC

Quality Control

Memo

MF
11-03-01

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

Picklist Print

Monday, March 28, 2011 7:24:54 AM

Page 1

Work Order ID: 67520



Parent Item: D3183-045



Parent Item Name: Bearing Assembly

Start Date: 3/28/2011

Required Date: 3/30/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP A 04.02.18 New issue (KJ/DS)

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-5 		Manufactured	No			110	Each	23.0000	1	50		3/28/2011	

Bearing

Location	Loc Qty	Loc Code
ST236	23	

MDELRLINR1.000



Delrin Round Bar 1"

Purchased

No

67065

130

f

14.0000

0.0333

11

1.752632

3/28/2011

Location	Loc Qty	Loc Code
MAT055	14	
116266	14	

116266

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

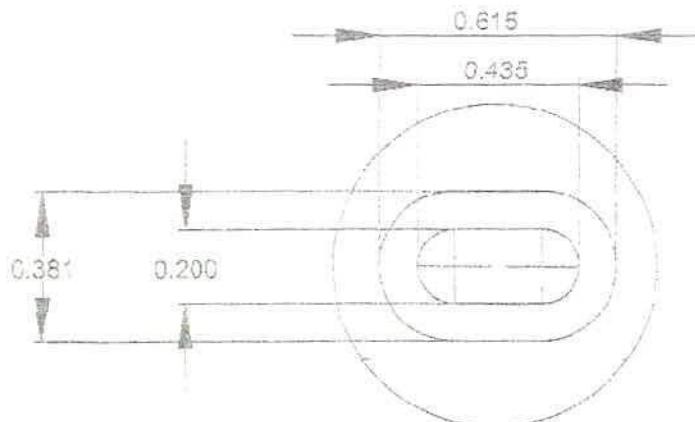
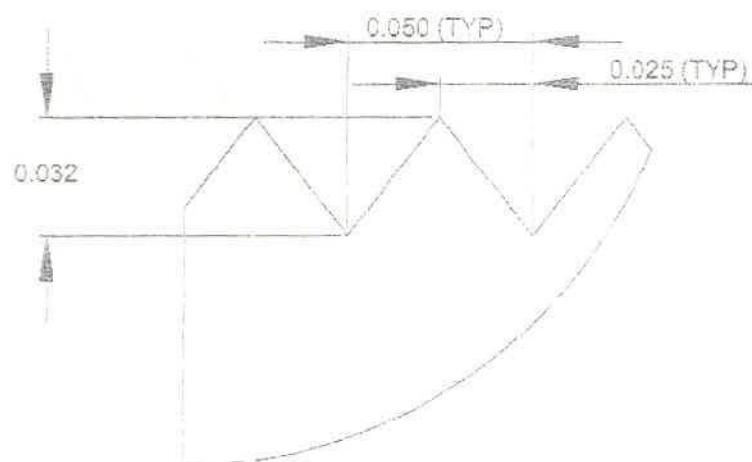
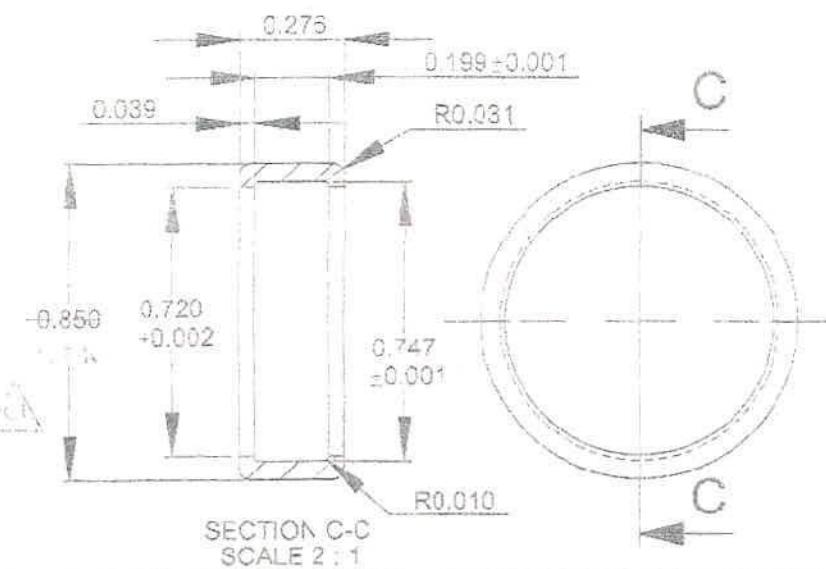
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
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NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE	04.02.17	D3183	SHEET 4 OF 4

DETAIL A (2:1)**DEO ATTACHED**DETAIL B (20:1)SECTION C-C
SCALE 2:1**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QS1018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DART AEROSPACE LTD	Work Order:	67520
Description: Cap	Part Number:	D3183-9
Inspection Dwg: D3183	Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: ME

Audited by:

Prototype Approval: N/A

Date: 11.3.28

Date: 10/3/28

Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3183-045)	KJ/RF	
B	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM	APR 2023

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